

**Work Order ID 79006****\*79006\***

Wednesday, January 18, 2012 11:30:32 AM

Page 1

Item ID: D407-667-205

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Crosstube Aft

Stop

**\*NS2\***Start Date: 1/18/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 1/18/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference: QC21

Approvals: Process Plan: MFDate: 12-01-18 Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D407-667-245 Rev F/DEO

290 QC5- Inspect part completeness to step on W/O 0.00

**\*290\***

QC

Quality Control

Memo

0.00

S170015

64

PULL FROM STOCK D407-667-205 B 72743

UPON SHIPMENT, IT WAS REALIZED THAT QC21 WAS NOT DONE. W/O  
IS CLOSED SINCE BED OF NOVEMBER BUT CAN'T FIND W/O.

QC WILL INSPECT AND ENSURE EVERYTHING COMPLIES.

QC21008

ATTACHED IS WORK ORDER SUMMARY WHICH SHOWS WHAT HAS  
BEEN PULLED AND WHO COMPLETED THE OPERATIONSCLOSE UNDER NEW BATCH NUMBER  
NEW LABELS REQU'D

300

Identify as per dwg &amp; Stock Location: \_\_\_\_\_ 0.00

**\*300\***

Packaging

Packaging

Memo

0.00

**Work Order ID 79006****\*79006\***

Page 2

Wednesday, January 18, 2012 11:30:32 AM

Item ID: D407-667-205

Accept

**\*N900040100\***

Setup

Start

**\*NS1\***

Revision ID:

Item Name: Crosstube Aft

Stop

**\*NS2\***

Start Date: 1/18/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 1/18/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference: QC21

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

310

QC21- Final Inspection - Work Order Release

0.00

**\*310\***

QC

Quality Control

Memo

0.00

12/1/18 JH

MF  
12-01-08

# Work Order Summary

Wednesday, January 18, 2012 11:36:21 AM

REFERENCE ONLY

Page 1 of 3

Criteria : Work Order ID: 72743 Item ID: D407-667-205 Product Family CROSSTUBES  
 Work Order Start Dates 8/11/2011 to 8/11/2011 11:59:59 PM Work Order Required Dates 8/31/2011 to  
 8/31/2011 11:59:59 PM  
 All References

Work Order Status Costed

<b>Work Order ID</b>	72743	<b>Required Qty</b>	1.0000	<b>Status Code</b>	Costed
<b>Item ID</b>	D407-667-205	<b>Accepted Qty</b>	1.0000	<b>Scrap Qty</b>	0.0000
<b>Item Name</b>	Crosstube Aft				
<b>Current Acct Value</b>	\$3,244.481				
<b>Start Date</b>	8/11/2011	<b>Required Date</b>	8/31/2011	<b>Completed Date</b>	11/4/2011 3:25:19 PM

Standard	<b>** Actual **</b>	<b>** Acct. Value **</b>	<b>** Variance **</b>	<b>** Variance % **</b>
<b>Direct Costs</b>	<b>Total</b>	<b>Each</b>	<b>Each</b>	<b>Each</b>
<b>Material</b>	\$1,327.677	\$1,327.677	\$1,278.692	(\$48.985) -3.83%
<b>Labor</b>	\$562.480	\$562.480	\$410.737	(\$151.743) -36.94%
<b>Outplant</b>	\$60.583	\$60.583	\$70.100	\$9.517 13.58%
<b>Variable Burden</b>	\$0.000	\$0.000	\$0.000	\$0.000 0.00%
<b>Fixed Burden</b>	\$1,305.560	\$1,305.560	\$881.200	(\$424.360) -48.16%
<b>Material Burden</b>	\$0.000	\$0.000	\$0.000	\$0.000 0.00%
<b>** Total **</b>	<b>\$3,256.300</b>	<b>\$3,256.300</b>	<b>\$2,640.729</b>	<b>(\$615.571)</b>

<b>Item ID/Item Name</b>	<b>Required Qty</b>	<b>Issue Code</b>	<b>Issue Date</b>	<b>Issued Qty</b>	<b>Cost Amount</b>
<b>PO ID</b>	<b>PO Line Nbr</b>	<b>PO Receiver Date</b>	<b>Domestic Unit</b>	<b>PO Receipt Qty</b>	<b>Domestic Received Amt</b>
ANS-10A			Price		Certification Standard
Bolt					
PO Rout Seq ID		PO Vendor ID	VC-ACU002		
AN5-10A	7	10/28/2011 9:12:44 AM	\$58.4583	1.0000	11/3/2011 10.0000 \$1.432
Bolt					
		4.0000			
			11/3/2011	4.0000	\$2.345
AN5-34A					
Bolt					
		4.0000			
			11/3/2011	4.0000	\$2.208
D2873-043					
Nut Plate Assembly					
		2.0000			
			11/4/2011	2.0000	\$56.247
D2873-045					
Nut Plate Assembly					
		2.0000			
			11/4/2011	2.0000	\$66.194
D2894-1					
2.750 Support					
		1.0000			
			11/4/2011	1.0000	\$482.085
D3190-1					
Chafing Shield					
		2.0000			
			11/4/2011	2.0000	\$17.287
D3595-063-450					
RUBBER CUSHION					
		2.0000			
			11/4/2011	2.0000	\$1.095
D407-667-205TRN					
Crosstube Turning Detail					
		1.0000			
			10/20/2011	1.0000	\$1,607.864
MS20601-AD4W8					
RIVET					
		14.0000			
			11/4/2011	14.0000	\$6.775

MS21042L5	Nut	4.0000	11/3/2011	4.0000	\$1.758
MS21920-22	Clamp(per MIL-DTL-8783C)	4.0000	11/4/2011	4.0000	\$54.568
MS21920-25	Clamp(per MIL-DTL-8783C)	2.0000	11/4/2011	2.0000	\$60.955
NAS1149D0563J	Washer	18.0000	11/4/2011	18.0000	\$1.098
				<b>Total Matl Amts:</b>	<b>\$2,361.910</b>

Invoice Rout Seq ID	Invoice Vendor ID	vc-acu002										
Invoice ID	Invoice Line Nbr	Invoice Date	Invoice Unit Price	Invoice Qty	Invoice Amt							
0000090671	7	11/15/2011 10:50:33 AM	60.583333	1.0000	\$60.583							
<b>Work Center</b> CNC Bend 1												
Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts

drou02	10/19/2011	120	0.84	0.42	0.00	0.00	2.00	\$9.066	\$0.000	\$18.010	\$0.000	\$27.076
	10/20/2011	120	0.00	0.00	1.23	1.23	1.00	\$0.000	\$26.617	\$52.877	\$0.000	\$79.493
PAQU03	10/19/2011	120	0.00	0.00	0.51	0.25	2.00	\$0.000	\$5.467	\$10.860	\$0.000	\$16.327
	10/20/2011	120	0.00	0.00	1.44	1.44	1.00	\$0.000	\$31.105	\$61.793	\$0.000	\$92.897
	<b>Total:</b>		0.84	0.42	3.17	2.92	6.00	\$9.066	\$63.188	\$143.539	\$0.000	\$215.793

<b>Work Center</b> Crosstubes												
Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts

ouim01	10/26/2011	140	0.00	0.00	0.79	0.79	1.00	\$0.000	\$14.779	\$37.153	\$0.000	\$51.932
titl01	10/25/2011	140	0.00	0.00	2.91	1.45	2.00	\$0.000	\$27.352	\$68.758	\$0.000	\$96.110
	11/1/2011	230	0.00	0.00	0.19	0.10	2.00	\$0.000	\$1.804	\$4.535	\$0.000	\$6.339

230	0.00	0.00	0.68	0.34	2.00	\$0.000	\$6.406	\$16.104	\$0.000	\$22.511
11/2/2011										
230	0.00	0.00	0.86	0.43	2.00	\$0.000	\$8.134	\$20.447	\$0.000	\$28.581
230	0.00	0.00	2.61	1.31	2.00	\$0.000	\$24.604	\$61.851	\$0.000	\$86.455
230	0.00	0.00	0.44	0.22	2.00	\$0.000	\$4.161	\$10.460	\$0.000	\$14.621
230	0.00	0.00	2.73	1.37	2.00	\$0.000	\$25.692	\$64.585	\$0.000	\$90.277
11/3/2011										
230	0.00	0.00	1.99	1.00	2.00	\$0.000	\$18.729	\$47.081	\$0.000	\$65.809
<b>Total:</b>	0.00	0.00	13.21	7.00	17.00	\$0.000	\$131.662	\$330.974	\$0.000	\$462.635

### Work Center HandFXtube

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
-------------	-------------	------------	-------------	--------------------	-------------	--------------------	------------	--------------	--------------	-----------------	-----------------	---------------

ouim01	10/26/2011	0.00	0.00	0.49	0.49	1.00	\$0.000	\$9.211	\$23.154	\$0.000	\$32.364
	<b>Total:</b>	0.00	0.00	0.49	0.49	1.00	\$0.000	\$9.211	\$23.154	\$0.000	\$32.364

### Work Center SprayPaint

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
-------------	-------------	------------	-------------	--------------------	-------------	--------------------	------------	--------------	--------------	-----------------	-----------------	---------------

titl01	10/28/2011	0.00	0.00	2.31	1.15	2.00	\$0.000	\$21.690	\$54.525	\$0.000	\$76.215
10/29/2011											
210	0.00	0.00	1.16	0.58	2.00	\$0.000	\$10.879	\$27.348	\$0.000	\$38.226	
210	0.00	0.00	0.52	0.13	4.00	\$0.000	\$2.440	\$6.134	\$0.000	\$8.574	
<b>Total:</b>	0.00	0.00	3.98	1.86	8.00	\$0.000	\$35.009	\$88.006	\$0.000	\$123.015	

## 5.0 PARTS LIST

## 5.1 HIGH GEAR CROSSTUBES

Item	Qty -101	Qty -201	Qty -103	Qty -203	Qty -105	Qty -205	Part Number	Description
	X						D206-667-101	CROSSTUBE INSTALLATION, 206A/B HIGH FWD
		X					D206-667-201	CROSSTUBE INSTALLATION, 206A/B HIGH AFT
			X				D206-667-103	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 HIGH FWD
				X			D206-667-203	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 HIGH AFT
					X		D407-667-105	CROSSTUBE INSTALLATION, 407 HIGH FWD
						X	D407-667-205	CROSSTUBE INSTALLATION, 407 HIGH AFT
1	1						D206-667-141	CROSSTUBE ASSEMBLY, 206A/B HIGH FWD
2		1					D206-667-241	CROSSTUBE ASSEMBLY, 206A/B HIGH AFT
3			1				D206-667-143	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 HIGH FWD
4				1			D206-667-243	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 HIGH AFT
5					1		D407-667-145	CROSSTUBE ASSEMBLY, 407 HIGH FWD
6						1	D407-667-245	CROSSTUBE ASSEMBLY, 407 HIGH AFT
10	*2	*2	*2		*2		D2891-1	SUPPORT
11				*2			D2892-1	SUPPORT
12						*1	D2894-1	SUPPORT
13	*4	*4	*4		*4		D3595-063-395	RUBBER CUSHION
14				*4			D3595-063-450	RUBBER CUSHION
15						*2	D3595-075-430	RUBBER CUSHION
16	*4	*4	*4		*4		MS21920-20	CLAMP
17				*4		*4	MS21920-22	CLAMP
18						*2	MS21920-25	CLAMP (OR MS21920-24)
19	4	4	4		4		AN5-32A	BOLT
20				4			AN5-34A	BOLT
21	4	4	4	4	4		MS21042L5	NUT (OR MS21042-5)
22	8	8	8	8	8		NAS1149C0563J	WASHER (OR AN960JD516)
23						*2	D3190-1	CHAFING SHIELD
40	*2		*2	*2	*2	*2	D2873-043	NUT PLATE
41	*2		*2	*2	*2	*2	D2873-045	NUT PLATE
42		2					D2872-043	NUT PLATE
43		2					D2872-045	NUT PLATE
44	10		10				AN5-7A	BOLT
45		10		10	10		AN5-10A	BOLT
46	4	10	4		4		AN5-30A	BOLT
47				4			AN5-32A	BOLT
48			12				AN970-4	WASHER (OPTIONAL)
49		6					MS21042L5	NUT (OR MS21042-5)
50	10	12	10	10	10		NAS1149C0563J	WASHER (OR AN960JD516)
60		1					D3039-3	CENTER DRILL (TOOLING, NOT INSTALLED)

\*REFERENCE ONLY. PARTS ARE INCLUDED IN D206-667-141/-143/-241/-243 & D407-667-145/-245 ASSEMBLIES ABOVE

• COPYRIGHT © 2001 BY DART AEROSPACE LTD. •  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED  
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: D  
Date: 11.05.01